

Date: Monday, 2/19/2007 3:26:57 PM  
 User: Kim Johnston

## Process Sheet

|   |                                       |
|---|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services      | Drawing Name : FLOOR PROTECTOR RH     |
| Job Number : 30769                                  |                                       |
| Estimate Number : 11225                             |                                       |
| P.O. Number : <i>N/A</i>                            | Part Number : D32803                  |
| This Issue : 2/19/2007 S.O. No. : <i>N/A</i>        | Drawing Number : D3280 REV B          |
| Prsht Rev. : NC                                     | Project Number : N/A                  |
| First Issue : <i>N/A</i> Type : PURCHASED PARTS     | Drawing Revision : B                  |
| Previous Run : 25748                                | Material : <i>N/A</i>                 |
| Written By : <i>[Signature]</i>                     | Due Date : 3/15/2007 Qty: 10 Um: Each |
| Checked & Approved By : <i>[Signature] 07.02.19</i> |                                       |
| Comment : Est Rev: 04.07.01 New issue KJ/JLM        |                                       |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *3136*

Description: Floor Protector RH

Possible Supplier: Delastek

Certificate of Conformity is required

*C 7/102121 (10)*

2.0

D32803P

Floor Protector, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 Floor Protector, RH

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure certificate of conformity is attached

*C 7/13/22*

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

*C 7/03.29 (10)*

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*C 7/13/30 (10)*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 07/04/04

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 3:26:57 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR RH

Job Number: 30769

Part Number: D32803

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10  
107/04/04

Job Completion



U 07-04-04

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

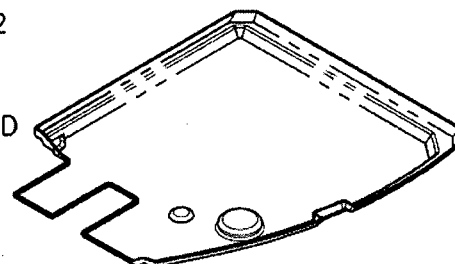
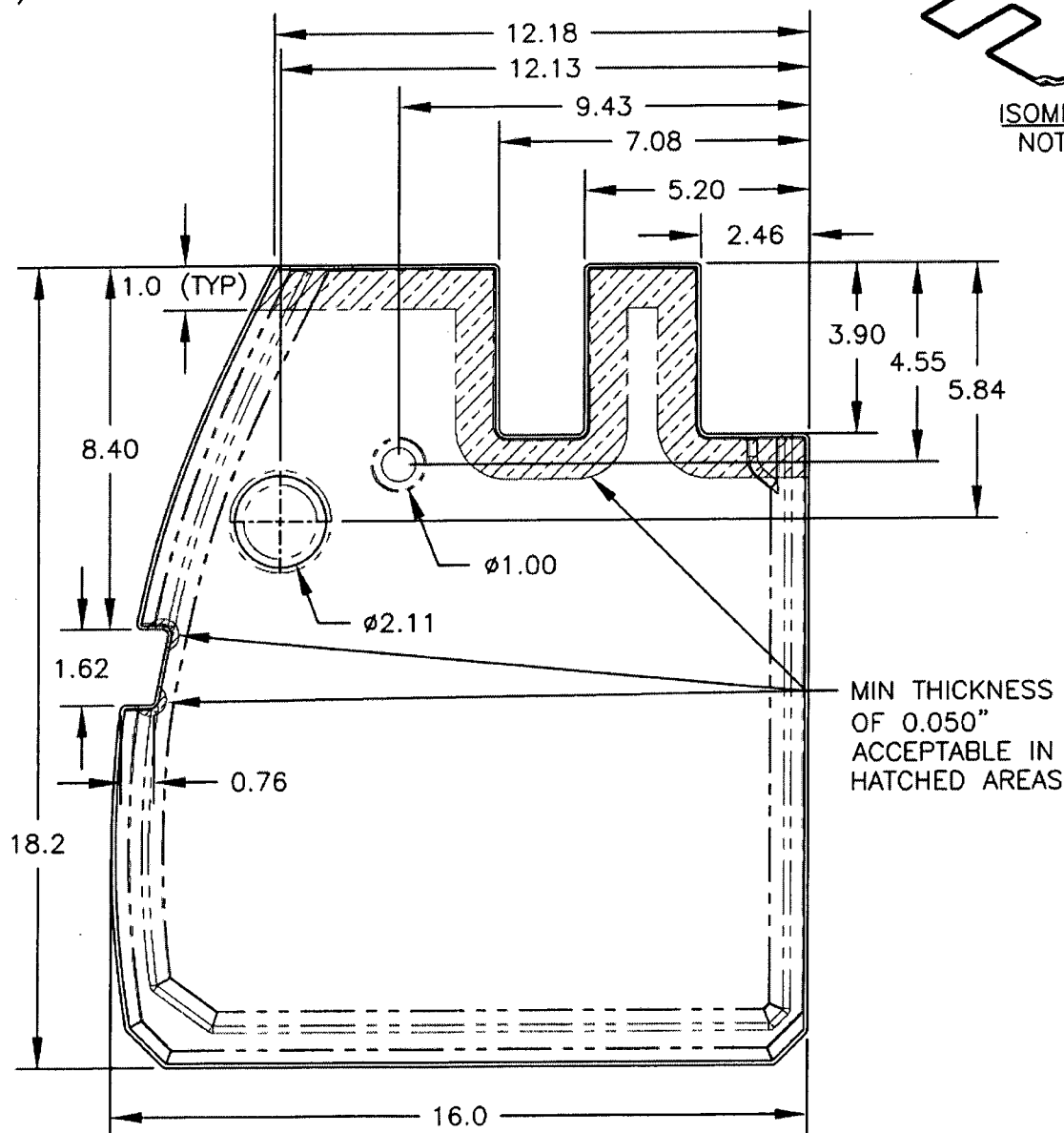
NOTE: Date & initial all entries

**DART**

|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>UP</i>           | DRAWN BY<br><i>UP</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3280                              | REV. B<br>SHEET 1 OF 2 |
| DATE<br>05.11.25              |                                | TITLE<br>FLOOR PROTECTOR                          | SCALE<br>1:4           |
| A                             | 04.04.05                       | NEW ISSUE   |                        |
| B                             | 05.11.25                       | NOW LEXAN, DIMS AS MANUFACTURED                   |                        |

**D3280-1 FLOOR PROTECTOR**

- 1) THERMOFORM USING MOLD D3280-1T1, TRIM USING D3280-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

ISOMETRIC DETAIL  
NOT TO SCALE**RELEASED**  
05/12/01

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WITHOUT NOTICE  
WORK ORDER  
NO. 30769

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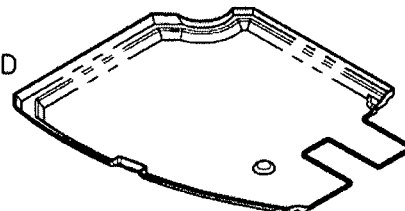
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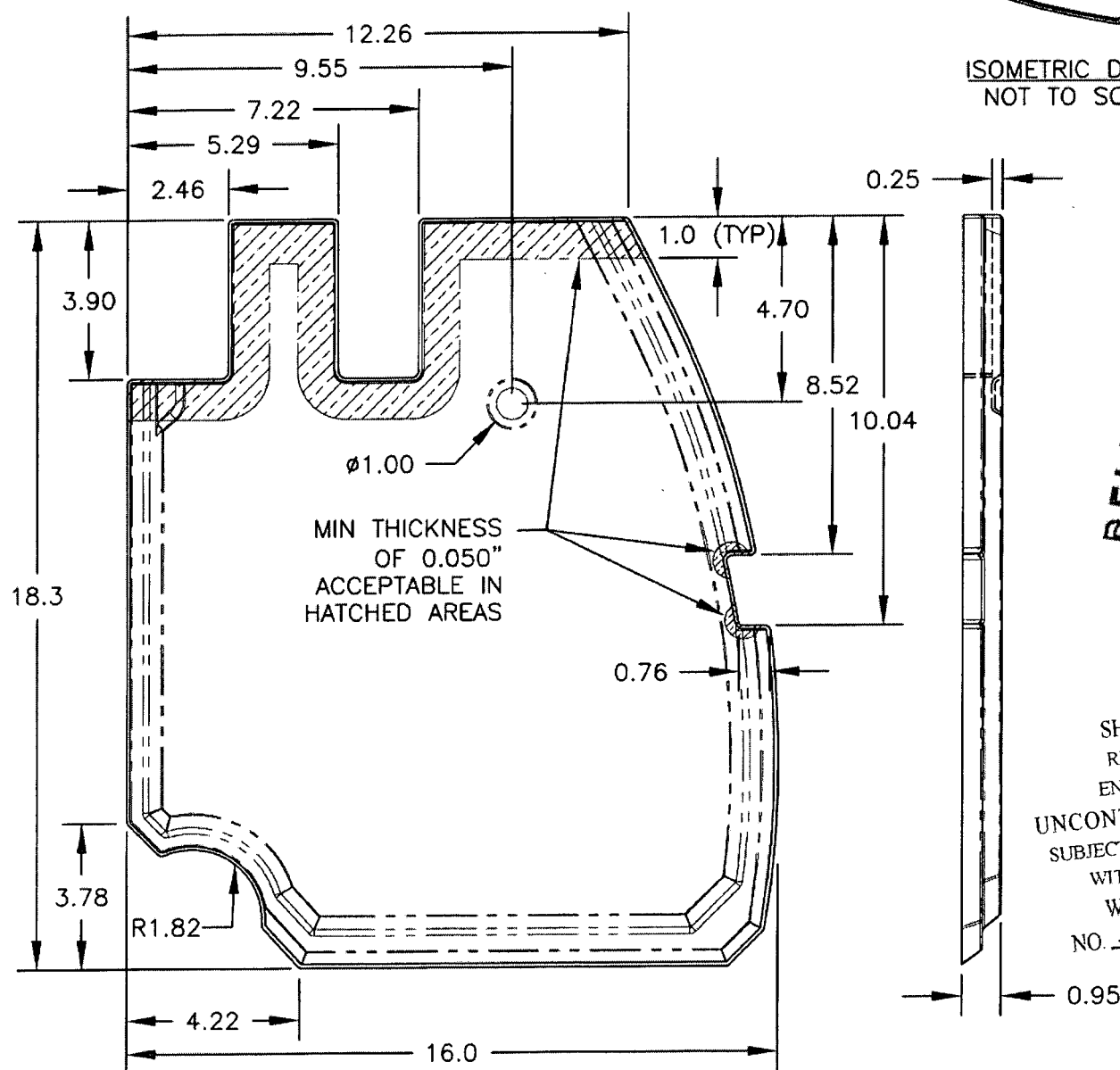
|                      |                       |   |                        |
|----------------------|-----------------------|---|------------------------|
| DESIGN<br><i>CP</i>  | DRAWN BY<br><i>CP</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>CP</i> | APPROVED<br><i>CP</i> | DRAWING NO.<br>D3280                              | REV. B<br>SHEET 2 OF 2 |
| DATE<br>05.11.25     |                       | TITLE<br>FLOOR PROTECTION                         | SCALE<br>1:4           |

### D3280-3 FLOOR PROTECTOR

- 1) THERMOFORM USING MOLD D3280-3T1, TRIM USING D3280-3T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080 EXCEPT AS SHOWN



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05/12/01

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DELASTEK COMPOSITES INC.  
2699, 5<sup>ème</sup> Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

|            |       |
|------------|-------|
| Invoice #  | 11735 |
| Customer # | DART  |

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

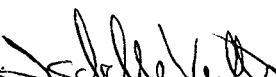
Telephone: 613-632-5200

Contact: Linda Lacelle

| Ship via     |            | F.O.B.        |             | Terms  |            | Salesperson              |  |
|--------------|------------|---------------|-------------|--|------------|--------------------------|--|
| PURO COLLECT |            | Origin        |             | Net30 days   |            | Claude Lessard, ext. 233 |  |
| Ship date    | Order Date | Our PO #      | Order by    |  | Your PO #  | GST/PST #                |  |
| 16/03/07     | 21/02/07   | 5175          | C. Lavoie   |  | PO00003136 |                          |  |
| Order Qty    | B.O. Qty   | Current Ship. | Item #      | Item Description   |            |                          |  |
| 10           | 0          | 10            | DKC134-0048 | Floor Protect LH N° D3280-1P ( F6006 )<br>Selon dessin D3180 Rev.: B<br><br>Dart Aerospace<br><br>JOB: 41080      QTÉ: 10<br><br>U de M : Each |            |                          |  |
| 10           | 0          | 10            | DKC134-0049 | Floor Protect RH N° D3280-3P ( F6006 )<br>Selon dessin D3180 Rev.: B<br><br>Dart Aerospace<br><br>JOB: 41081      QTÉ: 10<br><br>U de M : Each |            |                          |  |

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

Accepted by

  
Quality department



☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

AQ-357

Date: Lundi, 2007-02-26 10:50:29  
 Utilisateur: Sylvie Hamel

## Feuille de Procédé

 Client : DART Dart Aerospace Ltd.  
 Numéro Job : 41081  
 Numéro Soumission : 2388  
 Numéro B.A. :  
 Cette fois : 2007-02-26 No. B.V. :  
 Prsht Rev. : NC  
 Prem. fols : Type :  
 Job précédente : 41069

 Nom Dessin : FLOOR PROTECTOR  
 Numéro Article : DKC134-0049  
 Numéro Dessin : D3280  
 Projet Numéro : DKC134  
 Révision dessin : B  
 Matériel : F6006  
 Date Dûe : 2007-03-02

Qté: 12 Udm: UNITE

 Écrit par :  
 Vérifié & Approuvé par :  
 Commentaires : N° de pièce: D3280-3


10.03.07

Process Sheet Rév.: 00 Création du premier

## Produit additionnel

Numéro Job:



| # Séq.: | Machine ou Opération: | Description :                                  |
|---------|-----------------------|--|
| 1.0     | APL0016               | Lexan F6006 Noir N° 700 48" x 96" x .125" Thk. |

 Commentair Qty.: 0.167 UNITE(s)/Unit Total: 2.004 UNITE(s)  
 Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

N° de Lot: 1-5913-1

2.0 SÉCHAGE/ ANEAL

SÉCHAGE / ANEALING


 Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.4000Hrs  
 SÉCHAGE DU MATÉRIEL

 Sécher le matériel dans le four à 250° F pendant 6 heures.  
 Inscrire sur la charte de température le numéro de Job du matériel au séchage.  
 # de cuisson: 5543

3.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART


 Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 36.0000Hrs  
 TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.



Quantité: 12 Date: 8-3-07 Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_



# Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41081

Nom Dessin: FLOOR PROTECTOR  
Numéro Article: DKC134-0049

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

4.0

THERMOFORMAGE2

THERMOFORMAGE DES PIÈCE DART



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 2.0000Hrs  
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3280-3 à l'aide du moule N° D3280-3T1 sur le thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 12 Date: 14-3-07 Sceau: 9M

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

5.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 2.0000Hrs  
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3280-3 à l'aide du gabarit de trimage N° D3280-3T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 12 Date: 14-3-07 Sceau: F.O. 14/03/07

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

6.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.0000Hrs  
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 12 Date: 15/3/07 Sceau: [Signature]

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

7.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.0000Hrs  
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR

Numéro Job: 41081

Numéro Article: DKC134-0049

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

N° de pièce: D3280-3

N° de Job: 41081Date de fabrication: 14-3-07

Sceau d'inspection.

Quantité: 12 Date: 14-3-07 Sceau: Am

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

formation 9

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.0000Hrs

EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3280-3

Date de fabrication: \_\_\_\_\_

N° de job: \_\_\_\_\_

Quantité: 12 Date: 15/3/07 Sceau: \_\_\_\_\_

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

